

Blue

Work Order ID 86562

\*86562\*

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July-05-12 10:34:32 AM

Item ID: D3413-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Ring

Start Date: 7/05/12

Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 7/20/12

Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3413

Rev A

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3413

Dwg Rev: A

Prog Rev: A

2- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

10 0 Jm 12-7-12

10 0 Jm 12-7-12

304 .350 X 4"

# Work Order ID 86562

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Item ID: D3413-1 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Ring  
 Start Date: 7/05/12 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 7/20/12 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00							
			DAS 16 9-23	17/01/13		710			
155 <b>*155*</b> SprayPaint Spray Painting	Memo PRIME B <u>117319</u> DELFLEET BLUE B <u>121149</u> CLEAR DELFLEET B <u>121703</u>	0.00 0.00							
						AB	12 - 7 - 15	10	
165 <b>*165*</b> QC Quality Control	QC14- Inspect Spray Paint  Memo	0.00 0.00							
			DAS 16 9-23	17/01/16					

**\*86562\***

July-05-12 10:34:32 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*10\***

**\*10\***

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

170

Identify as per dwg & Stock Location:

0.00

**\*170\***

### Packaging

## Memo

0.00

### Packaging

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

## Memo

0.00

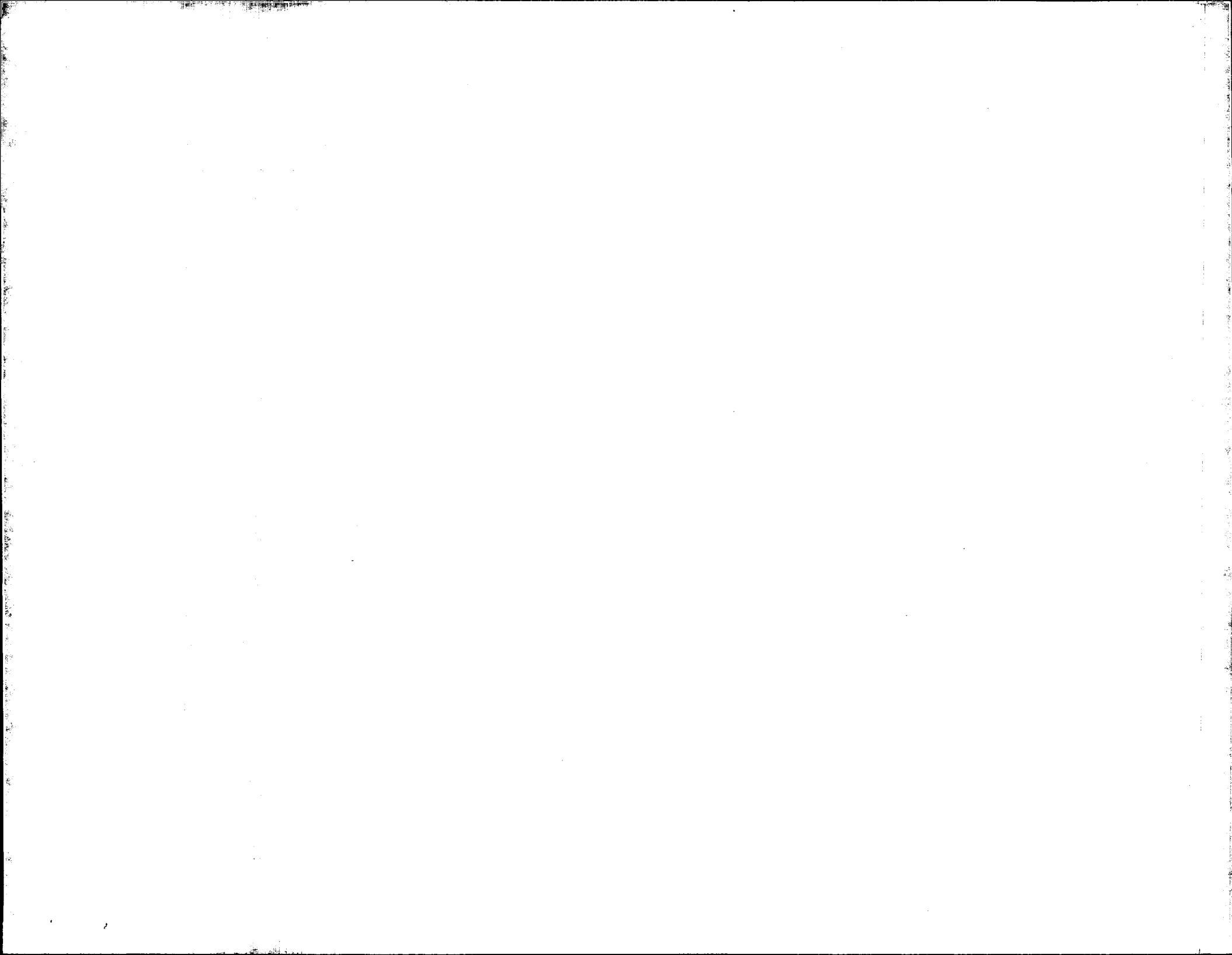
## Quality Control

10x

SP  
12-7-16

12/7/18 *[Signature]*

MF  
12-07-16



# Picklist Print

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Work Order ID: 86562

Parent Item: D3413-1

Start Date: 7/05/12

Required Date: 7/20/12

Parent Item Name: Ring

Start Qty: 10.00

Required Qty: 10.00

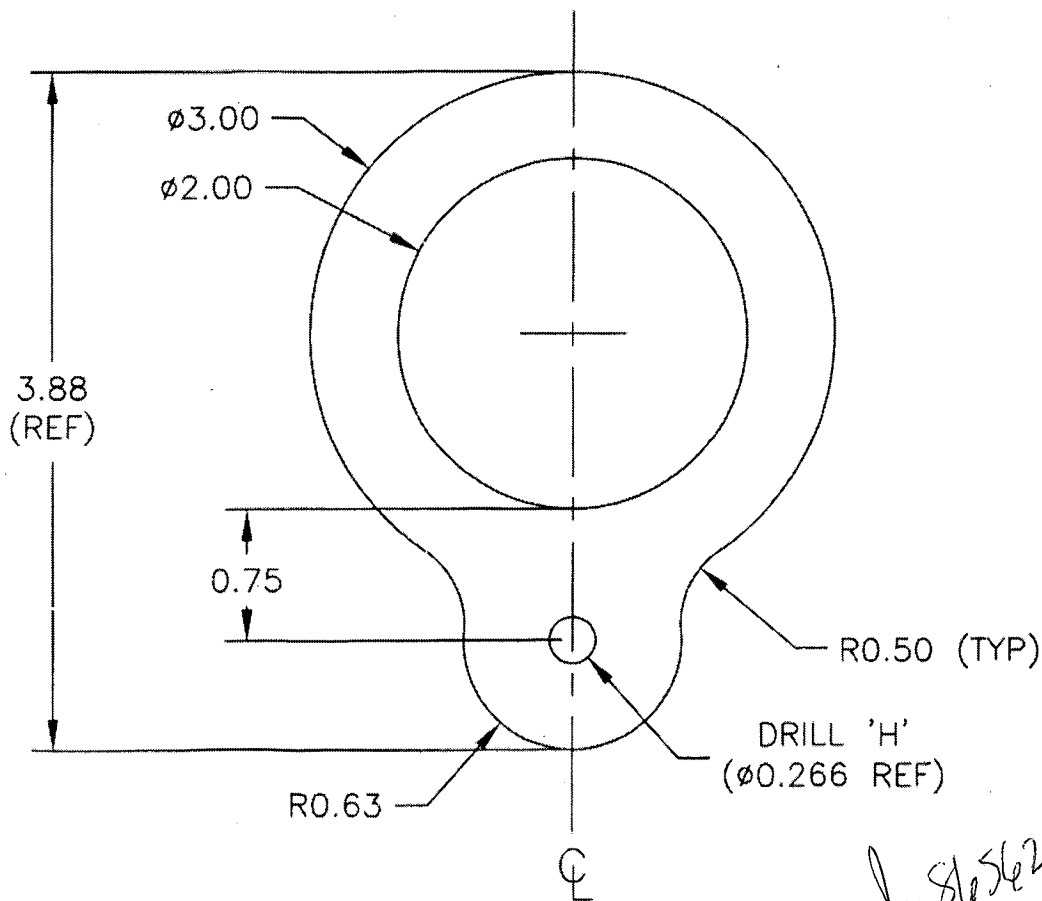
Comments: IPP Rev:A05.09.13New issueKJ/JLM  
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000 304 BAR .250 x 4.00		Purchased	No			100	f	37.7000	0.25	2.6315789			
										2.7			Im 12-7-12
				<u>Location</u>				<u>Loc Qty</u>					
				MAT050				37.7					
				119043				17					
				119766				8.7		119766			
				119840				12					



**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	

**RELEASED**  
05-09-06 *[Signature]***D3413-1 RING**

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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